

Work Order ID 70524

Friday, June 10, 2011 11:41:53 AM



Page 1

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								

100

0.00



Large Fab

Large Fab

Memo

0.00

Weld assembly as per dwg D3443

M107051

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

[Handwritten signature]

[Handwritten signature] 11.07.06 (4)

[Handwritten signature] 11.07.06 (4)

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating									
	Memo	0.00							
	1-Mask holes as per dwg D3443								
	START TIME: 12:00								
	OVEN TEMPERATURE: 400								
	FINISH TIME: 12:30								
140	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control									
	Memo	0.00							
150	Small Fab	0.00							
	Small Fab								
Small Fab									
	Memo	0.00							
	Assemble bearing and ball plungers as per dwg D3443 using DT9518								
	Ensure bearing rotates smoothly								

4X Ø M-11/07/07

H BR 11-7-7.

ES 11/07/08 (4)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/07/08

(4)

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

w/o: 70590 (10)
70589 (10)
70588 (10)
69654 (10)

SP 11/07/08 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/07/08
ME

11-07-08

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NOTE: Date & initial all entries

Friday, June 10, 2011 11:42:00 AM

[illegible]



Required Date: 6/15/2011


Required Qty: 4.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

[illegible]

WA022	6
69761	6
WA023	1
60230	1

D3453-1	Manufactured	No	100	Each	4.0000	1	4	<i>11.06.06</i>
								
Clevis								

WA023		4	
		4	
	100	Each	4.0000

D3965-4 Manufactured No 100 Each 4.0000 1 4
  *EP 4/07/08*
 Bearing, Spherical

ST100	4
60479	4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 11:42:00 AM

Page 2

Work Order ID: 70524

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D3966-4-750

Manufactured

No

100

Each

44.0000

2

8



Pin, Dowel



11.06.06

Location

Loc Qty

Loc Code

ST100

44

5871E

44

8

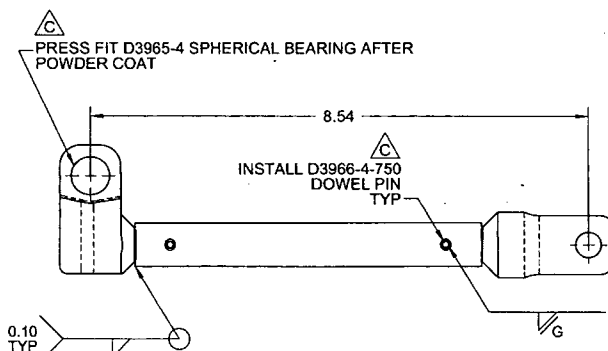
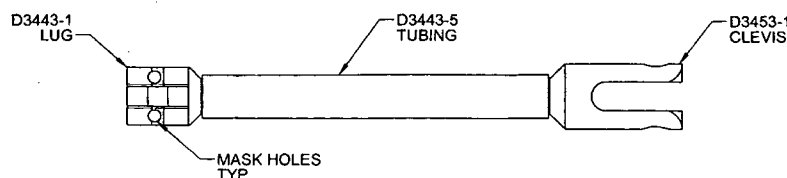
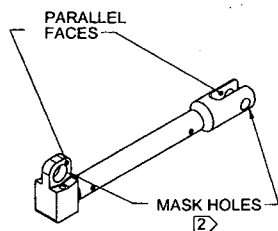
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NOTE: Date & initial all entries



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70524

11-06-10

RELEASED
09/08/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER PIN (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR PIN (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE, & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	NTS
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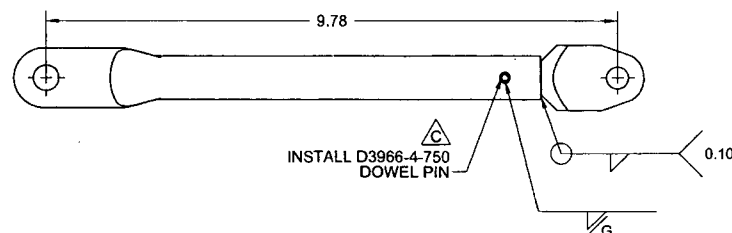
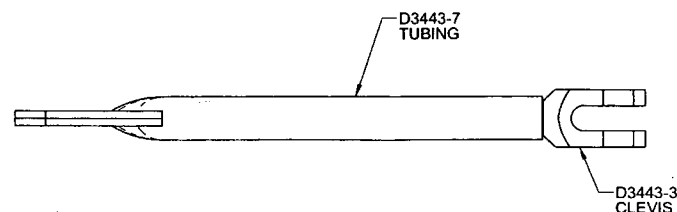
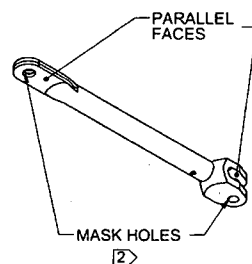
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN




D3443-043

w/0 70 524

RELEASED
09/06/25/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

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MFG. APPR.			D3443	SHEET 2 OF 4
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DE APPR.			STRUT WELDMENT ASSEMBLY	NTS
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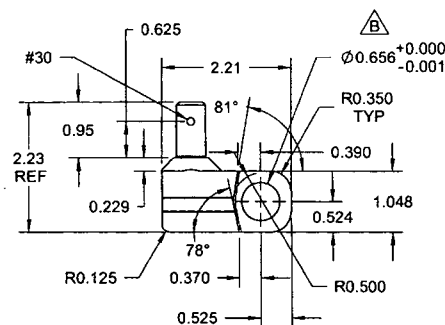
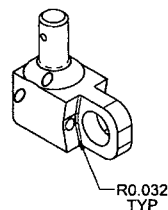
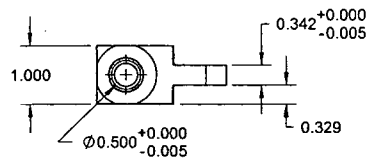
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

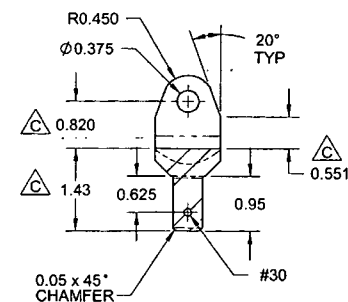
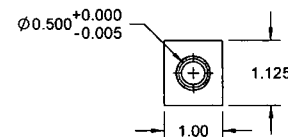
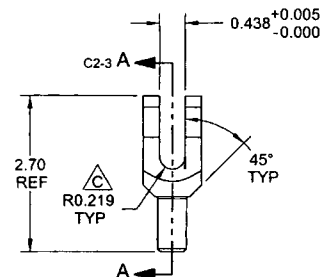
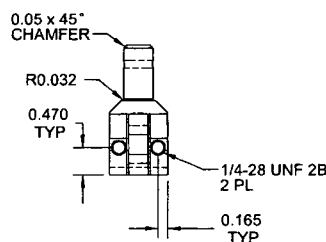
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D3443-1 LUG



SECTION A-A C4-3



D3443-3 CLEVIS

W/O 10524

RELEASED
09/08/25/16

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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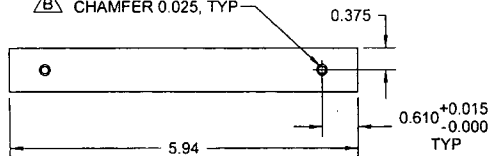
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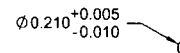
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DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025, TYP



D3443-5 TUBING

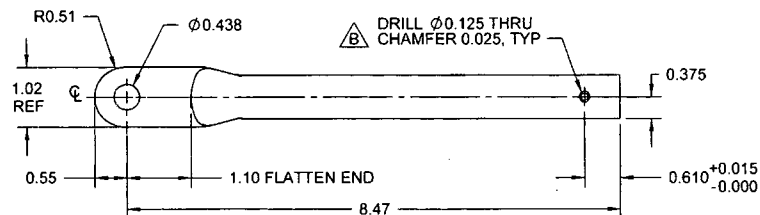
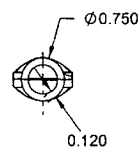
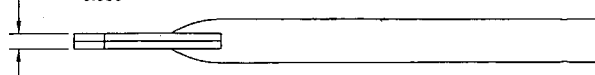


D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

0.260 +0.000
-0.030






D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

w/o 70524

RELEASED
01/28/25 MD

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